

Work Order ID 81398

81398

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Tuesday, March 13, 2012 4:11:55 PM

Item ID: D3826-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib / Gusset Assembly
 Start Date: 3/14/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/21/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: CHF Date: 12-03-13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3826	Rev B								

100
100
 Large Fab
 Large Fab
 Large Fab
 Memo
 1- assemble D2325 support gusset together
 2- locate D2325 on rib and weld as per dwg D3826
 A/R ER316 S.S. Rod Batch: ML15278

110
110
 QC
 Quality Control
 QC9- Inspect visual per QSI004- Fusion Welds
 Memo

120
120
 QC
 Quality Control
 QC5- Inspect part completeness to step on W/O
 Memo

12.04.10

12.04.11

6x

Schell

46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: BASKET	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DL/12-04-12

12/4/12

12-04-12

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 81398

Parent Item: D3826-041

Parent Item Name: Rib / Gusset Assembly

Start Date: 3/14/2012

Required Date: 3/21/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2235-1 Basket Rib		Manufactured	No			100	Each	19.0000	1	6		12.04.10	
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Location	Loc Qty	Loc Code
WA	5	
78636	5	
WA005	14	
66895	4	
79153	10	

D3929-041 Gusset Assembly		Manufactured	No			100	Each	2.0000	1	6			
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Location	Loc Qty	Loc Code
WA005 81255	2	
77675	2	

D3929-042 Gusset Assembly		Manufactured	No			100	Each	4.0000	1	6			
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Location	Loc Qty	Loc Code
WA005	4	
77677	4	

81254

12.04.10

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

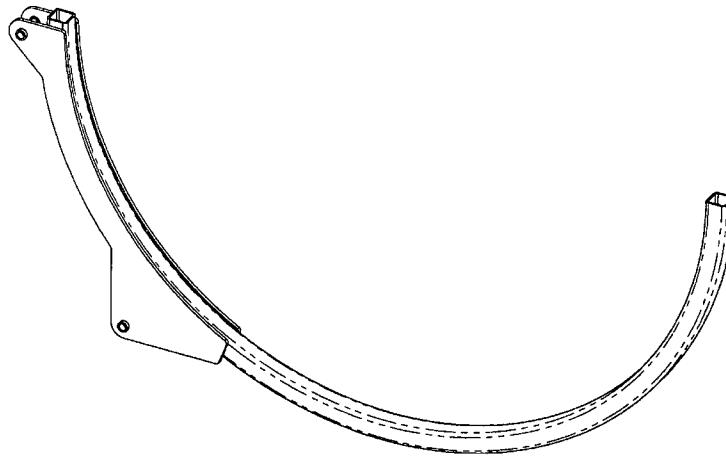
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8 7 6 5 4 3 2 1

ITEM	QTY. .041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△B



D3826-041 RIB/GUSSET ASSY

87398

RELEASED
09/04/16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.32 lbs

△B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD			
DRAWN	HAWKESBURY, ONTARIO, CANADA			
CHECKED	DRAWING NO. D3826		REV. B	
MFG. APPR.	TITLE RIB/GUSSET ASSY		SHEET 1 OF 2	
APPROVED	SCALE NTS			
DE APPR.	DATE 09.04.16			
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B D3929-042
GUSSET ASSEMBLY

B D3929-041
GUSSET ASSEMBLY

TYP

0.250

D2235-1
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED
8/13/95

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D3826	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 2
APPROVED		RIB/GUSSET ASSY	SCALE
DE APPR.			NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

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